



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4822-1
Job Sheet 167749



Part No: D4822-1

Job Qty: 10 ea

Part Name: Upper Deflector, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/6/17

Job Tracking No:

Due Date: 12/8/17

Created By: Chantal Lavoie

Type: Stock

Description:

Ship Via:

DWG D4822 Rev.C

DAS
35

Bill of Materials 9-89

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/7/17	0.00	0.00	Start Up Machining		NR unit
100	Bandsaw	10 pcs		12/8/17	0.00	1.64	Bandsaw1		NR unit
110	Purchasing	10 pcs		12/8/17	0.00	0.00	Purchasing		AT 18/02/20
115	Packaging	10 pcs		12/8/17	0.00	0.00	Packaging2		AT 18/02/20
117	QC	10 pcs		12/8/17	0.00	0.00	QC6		38
120	Outsource	10 pcs		12/8/17	0.00	0.00	Outsource5		AT 18/03/09
122	QC	10 pcs		12/8/17	0.00	0.00	QC14		11 MAR 12 2018
140	QC	10 pcs		12/8/17	0.00	0.00	QC5- Q66		9-89 MAR 1 2018
170	Packaging	10 pcs		12/8/17	0.00	0.00	Packaging3		21 MAR 13 2018
190	QC21-SA	10 Ea		12/8/17	0.00	0.00	QC21		21 MAR 14 2018

Part Op 100 - CUT AT 32.00" LONG

Descriptions: 110 - ISSUE P/O: 038259 POSSIBLE SUPPLIER: WEJAY ***1 BLANK MAKES 2 PARTS**** Certificate of conformaty required
115 - Receive & Inspect for Damage & Mat'l Certs
117 - QC6- All purchased or subcontracted products
120 - HARD ANODIZE IAW MIL-A-8625 TYPE 3 COLOUR BLACK PRIME AS PER DWG NOTE #2
122 - QC14- Inspect Spray Paint
140 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location:
190 - QC21- Final Inspection - Work Order Release

NOV 06 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6S4.000X4.000	14	13	0	0
110-Purchasing	D4822-1P	10	0	0	0

Part Specifications

Specifications could not be found.



PART NO: D4822-1
Serial No/Batch: S043701
Revision:
Operation: Packaging
Change No:

Mfg Date: 02/20/18
Job No: 167749



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038259

Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: PO038259

PO Date: 11/6/17

Due Date: 11/20/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items												Unit	Extended
Line	Part	Rev	Supplier	Item	Description	Item Tax	Status	Due	Order	Received	Balance	Price (CAD)	Price
Item			Part No	No				Date	Quantity	Quantity			
1	D4970-3P				Windshield Deflector - Upper As per Dwg D4970 Rev. C		Firmed	11/20/17	2 Ea	0 Ea	2 Ea	\$1,095.00/Ea	\$2,190.00
Line Item Note job# 167748													
2	D4822-1P				Upper Deflector, LH As per Dwg D4822 Rev. C		Firmed	11/20/17	10 pcs	0 pcs	10 pcs	\$1,057.00/pcs	\$10,570.00
Line Item Note JOB# 167749													
3	D4822-2P				Upper Right Deflector As per Dwg D4822 Rev. C		Firmed	11/20/17	8 pcs	0 pcs	8 pcs	\$1,057.00/pcs	\$8,456.00
Line Item Note job # 167750													
4	D4821-1P				Windshield Deflector As per Dwg D4821 Rev. B		Firmed	11/20/17	8 pcs	0 pcs	8 pcs	\$1,095.00/pcs	\$8,760.00
Line Item Note job# 16751													
												Grand Total: \$29,976.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

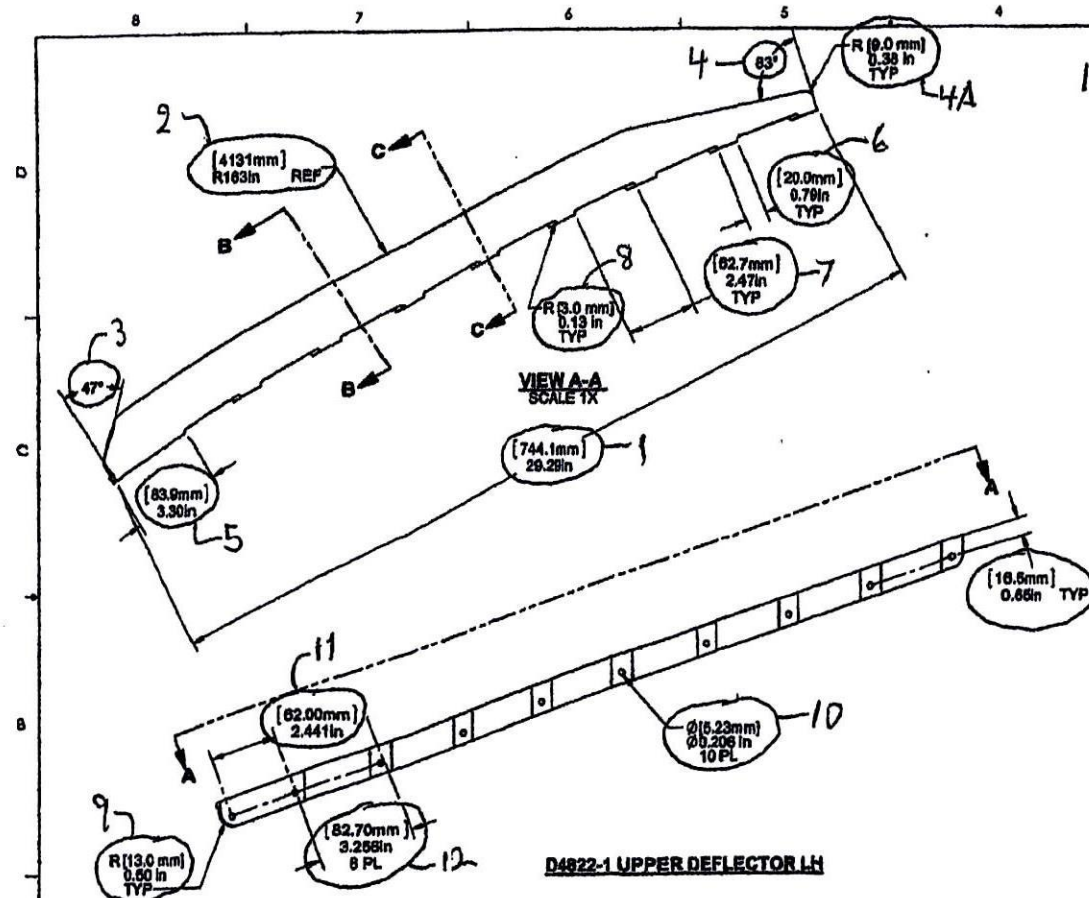
CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: Feb. 6, 2018	
		P.O.# PO38259 item 2	
		WEJAY JOB# 38873A	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4822-1P 'Upper Left Hand Deflector' Job Number: 167749	10	Machined complete per drawing req'ts.	D4822 / rev. C
Note: 1) Material supplied by Dart Aerospace: for qty 10 parts ref. DART Batch# S029880 . 2) 1st Article Inspection Report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith
Authorized Q.A. Signatory



D4822-1 UPPER DEFLECTOR LH

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS QQ-A-200/11 (REF DART SPEC. M7075188)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625F TYPE III, CLASS 2, COLOR BLACK.
PRIME IAW MIL-P-23377J TYPE I CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4822-1", AGUSTA WESTLAND P/N "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE,
USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 5.2
- 7) WEIGHT: 1.22 LBS (0.6 KG)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4822-1.c.IGES (OR D4822-1.a.STEP)

**SECTION B-B
SCALE 1.5X**

**SECTION C-C
SCALE 1.5X**

RELEASED

2014 FEB 25

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	VS	HAMMERSBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4822	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	UPPER DEFLECTOR	NTB
DATE	14.02.04	COPYRIGHT © 1975 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES FOR WHICH IT WAS ORIGINALLY DESIGNED AND NOT FOR ANY OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38873

PAGE: 1 of 1

CUSTOMER: Dart Aerospace

CUST. P.O.# 38259 ITEM 2

PART No. D4822-1

DESCRIPTION: Deflector Left Hand

DWG No. D4822

REV. C

E.C.O. --

MATERIAL: DART BATCH#

INSPECTOR: CLIFF SMITH

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: —

N.C.R.# —

DATE: FEB 5, 2018



INSTRUCTIONS, COMMENTS: Standard Tolerances per DART QSI 018 unless otherwise noted
-First Article Inspection-

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	29.29"	View A-A	±.03	2/C6	29.280	1	Acc.
2	R163" ref		±.10	2/D7	R 163	1	Acc.
3	47°		±.5°	2/C8	46.5°	1	Acc.
4	83°		±.5°	2/D5	82.5°	1	Acc.
4A	R 0.38" typ.		±.03	2/D4	R.375 TYP.	1	Acc.
5	3.30"		±.03	2/C8	3.311	1	Acc.
6	0.79" typ.		±.03	2/D5	.796-.800	1	Acc.
7	2.47		±.03	2/D5	2.458-2.470	1	Acc.
8	R 0.13 typ.		±.03	2/C6	R.125 TYP.	1	Acc.
9	R0.50" typ	10 pl.	±.03	2/B8	R.50 TYP.	1	Acc.
10	Ø0.206 hole thru		+0.005/-0.001	2/B5	.207-.209 Ø	1	Acc.
11	2.441"		±.010	2/B7	2.441	1	Acc.
12	3.256" typ.	8 pl.	±.010	2/B7	3.255-3.257	1	Acc.
13	0.65" typ.	10 pl.	±.03	2/B4	.648-.654	1	Acc.
14	0.157"	Section B-B	±.01	2/D3	.1595-.1615	1	Acc.
15	R0.13" typ. e-model is .200"R		±.03	2/D2	R.200 TYP.	1	Acc.
16	.099"		±.01	2/D2	.0955-.1045	1	Acc.
17	1.04"		±.03	2/D3	1.045-1.046	1	Acc.
18	1.87"		±.03	2/D3	1.871-1.876	1	Acc.
19	0.236"	Section C-C	±.01	2/B1	.2315-.2415	1	Acc.
20	0.157"		±.01	2/C3	.1595-.1615	1	Acc.
21	2.01"		±.03	2/B3	2.008-2.014	1	Acc.
22	1.04"		±.03	2/B2	1.045-1.046	1	Acc.
23	R0.13" typ. e-model is .200"R		±.10	2/C2	R.200 TYP.	1	Acc.
24	Deburring	Per note 5	.005-.010	2/A8	PASSED	1	Acc.
25	Identification	Per note 6		2/A8	TAGGED WITH DART PART No. & JOB No.	1	Acc.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039091

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039091
PO Date: 2/22/18
Due Date: 3/1/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
FEB 28 2018

Items				Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Line Item	Job	Part	Description							
1	167749	D4822-1	Upper Deflector, LH HARD ANODIZE IAW MIL-A- 8625 TYPE 3 COLOUR BLACK PRIME AS PER DWG D4821 REV. B	Firmed	3/1/18	10 pcs	0 pcs	10 pcs	\$31.45/pcs	\$314.50
2	169823	D4822-2	Upper Right Deflector Hard Anodize, Color Black and Prime as Per Dwg D4822 Rev. C	Firmed	3/1/18	5 pcs	0 pcs	5 pcs	\$31.45/pcs	\$157.25
3	172047	D5155-043	Co-Pilot Collective Head Assembly (212/412) Anodize Black as per Dwg D5155 Rev. B	Firmed	3/1/18	2 pcs	0 pcs	2 pcs	\$6.25/pcs	\$12.50
4	170452	646.3110	Channel Issue P/O to ATG: 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	3/1/18	12 pcs	0 pcs	12 pcs	\$12.10/pcs	\$145.20
5	171985	646.3313	Upper Guide Issue P/O to ATG: Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed	3/1/18	20 pcs	0 pcs	20 pcs	\$14.55/pcs	\$291.00
6	168292	647.1712	Gusset Issue P/O to ATG: Hard Anodize, Color Black and Prime as per Dwg 647.1700 Rev. E	Firmed	3/1/18	4 pcs	0 pcs	4 pcs	\$14.10/pcs	\$56.40
		171188		Firmed	3/1/18	16 pcs	0 pcs	16 pcs	\$14.10/pcs	\$225.60
Sub Total:						20	0	20		\$282.00
7	169389-A	647.7821	Eye Bolt Fitting LH Issue P/O to ATG: 1- Black	Firmed	3/1/18	4 pcs	0 pcs	4 pcs	\$10.50/pcs	\$42.00

DAS
11
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914735

Date: 07-Mar-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
10 pcs MLC 9/03/18	Part: D4822-1 Upper Deflector, LH	Rev: B	
	Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22577 PO: PO039091 Line: 1		
12 ea	Part: 646.3110 Channel	Rev: NC	
	Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22580 PO: PO039091 Line: 4		
4 ea	Part: 647.7821 Eye Bolt Fitting LH	Rev: A	
	Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22583 PO: PO039091 Line: 7		
16 ea	Part: 650.9201 Eyelet Bracket Assembly	Rev: A	
	Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22584 PO: PO039091 Line: 8		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: _____ Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914735

Date: 07-Mar-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Certified Signature: <u>07/03/2017</u>	
	Receiver Signature: <u>[Signature]</u>	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	Made in Canada.	